

## Amendments to Specification

**Please substitute paragraphs [0014] and [0015] with the following paragraphs:**

**[0014]** Two through holes 26 and 28 extend the whole length of drill 10 from the end 30 of mounting portion 16 to the cutting faces 32 and 34 of cutting head end 14. In prior drills such through holes have been used for the delivery of a liquid coolant/lubricant through the drill to the workpiece cutting site. The liquid coolant is maintained in a suitable reservoir apart from the cutting tool and delivered under high pressure through a machine tool spindle to the toolholder. But, in the practice of this invention, through holes 26 and 28 are formed and sized for holding a volume of oil-filled polymer material 36 for the lubrication of the cutting site/cutting faces ~~34, 36~~ 32, 34 interfaces.

**[0015]** Initially, through holes 26, 28 are injected or otherwise filled with a moldable slurry or mixture of thermoplastic polymer/lubrication oil/additive mixture 36. At some point in its processing the mixture may have been heated to disperse the oil and any additives in the polymer matrix. Depending upon the specific constituents of the mixture such heating may occur before or after the mixture is injected into holes 26, 28. Through holes 26, 28 are thus filled with an oil-containing solid mass 36 along the full length of each of the through holes 26 and 28. The portion of the oil-filled polymer material 36 at the cutting faces 32 and 34 of cutting head end 14 is available to provide oil at the working face of the tool when the tool is operated on a workpiece. As oil is wiped or otherwise removed from the worksite more oil is exuded by the polymer matrix down the length of each through hole ~~28, 30~~ 26, 28 to cutting faces 32, 34 and the work site. A reservoir other than the material in through holes 26 and ~~30~~ 28 is optional but not required. It is intended that the oil-filled material 36 in the through holes 26, 28 of the cutting tool 10 suffice during the useful life of the tool.